

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016024**Date Inspected:** 01-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 14-

This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ZPMC for OBG Segment 13AW side panel stiffener welds. This QA Inspector sign green tag document 13591 along with ZPMC and ABF QC Inspectors. See MT report TL-6028 generated this date for additional information. The following welds were tested:

SP3101-001-007, 008, 016, 023, 024, 033, 043, 044

Shielded Metal Arc Welding (SMAW) repair of OBG segment 13AE bottom panel bearing rod holes damaged during thermal cutting. ZPMC welder was identified as 201583. ZPMC QC was identified as Zhong Guo Hui. ZPMC QC was identified as Geng Wei. The repair welding appeared to be in conformance with welding procedure specification WPS-345-SMAW-3G(3F)-FCM and Critical weld repair report, B-CWR-1764.

Submerged Arc Welding (SAW) of OBG Segment 13BW bottom panel weld, SEG3014A-004. ZPMC welder was identified as 045270. ZPMC QC was identified as Zhang Lin. ZPMC CWI was identified as Geng Wei. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2c-S-2.

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## WELDING INSPECTION REPORT

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Bay 16-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Segment 13CW longitudinal diaphragm stiffener weld, SEG3036-001-082 and 083. ZPMC welder was identified as 201583. ZPMC CWI was identified as Wang Wei. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132.

Blast Bay 1-

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 10BW lower section base metal and weld surfaces. Areas requiring light grinding were marked for ZPMC personnel. Items which require repair were recorded for future repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation occurred this day.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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